

Shp April 12

Work Order ID 82315

\*82315\*

Page 1

March-28-12 2:39:12 PM

Item ID: D4526-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Maintenance Step Assembly

Start Date: 28/03/2012 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 11/04/2012 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/2012 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4526

A

100 Pick Kit

0.00

\*100\*

Packaging

Memo

0.00

Packaging

SX

ES 12/04/11

110

0.00

\*110\*

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg  
Torque screws up to 15-25 in- lbs

SX

φ

ES 12/04/11

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

S 12/04/11

ES

φ

042

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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012-04-12

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# Picklist Print

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Page 1

Work Order ID: 82315

\*82315\*

Parent Item: D4526-042

\*D4526-042\*

Parent Item Name: Maintenance Step Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 11.11.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

\*D4092-1\*  
Maintenance Step

Manufactured No

100

Each

4.0000

2

16

\*\*

Location

Loc Qty

Loc Code

GA

3

77852

1

80564

2

ST241A

1

74303

1

Manufactured No

100

Each

6.0000

1

8

\*\*

Location

Loc Qty

Loc Code

ST254

6

80087

6

Manufactured No

100

Each

13.0000

1

8

\*\*

Location

Loc Qty

Loc Code

ST195

13

80088

7

80562

6

D4527-1

\*D4527-1\*  
Bracket

Manufactured No

100

Each

13.0000

1

8

\*\*

EPB 12/04/11

B81734  
(100)

EPB 12/04/11

B82317  
(50)

EPB 12/04/11

5

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 82315

**\*82315\***

Parent Item: D4526-042

**\*D4526-042\***

Parent Item Name: Maintenance Step Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 8.00

Required Qty: 8.00

D4527-3 Manufactured No

100 Each 7.0000 1 8

**\*D4527-3\***

Bracket

\*\*

Location

Loc Qty

Loc Code

ST195

7

77208

1

80086

6

MS21042L3 Purchased No

100 Each 2,636.000 10 80

**\*MS21042L3\***

Nut

\*\*

Location

Loc Qty

Loc Code

ST300

2636

117441

16

117885

32

118451

5

118927

3

119017

2314

119075

166

121162

100

MS24694-S55 Purchased No

100 Each 183.0000 8 64

**\*MS24694-S55\***

Screw

\*\*

Location

Loc Qty

Loc Code

ST289A

183

119307

33

120833

50

120910

100

EP 12/04/11  
B 82316 (5x)  
EP 12/04/11  
50  
EP 12/04/11  
M 120142 (5x)  
35  
D

W/O:		WORK ORDER CHANGES					
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Page 3

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**\*82315\***

Parent Item: D4526-042

**\*D4526-042\***

Parent Item Name: Maintenance Step Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 8.00

Required Qty: 8.00

MS24694-S75

Purchased

No

100

Each

15.0000

2

16

**\*MS24694-S75\***

Screw

\*\*

Location

Loc Qty

Loc Code

GA

15

119892

15

NAS1149D0332J

Purchased

No

100

Each

3,575.000

10

80

**\*NAS1149D0332.J\***

Washer

\*\*

Location

Loc Qty

Loc Code

ST298

3575

105793

12

110985

4

117087

89

119042

38

119717

700

120644

732

121011

2000

*EP 12/04/11*

*10*

*EP 12/04/11*

*SD*

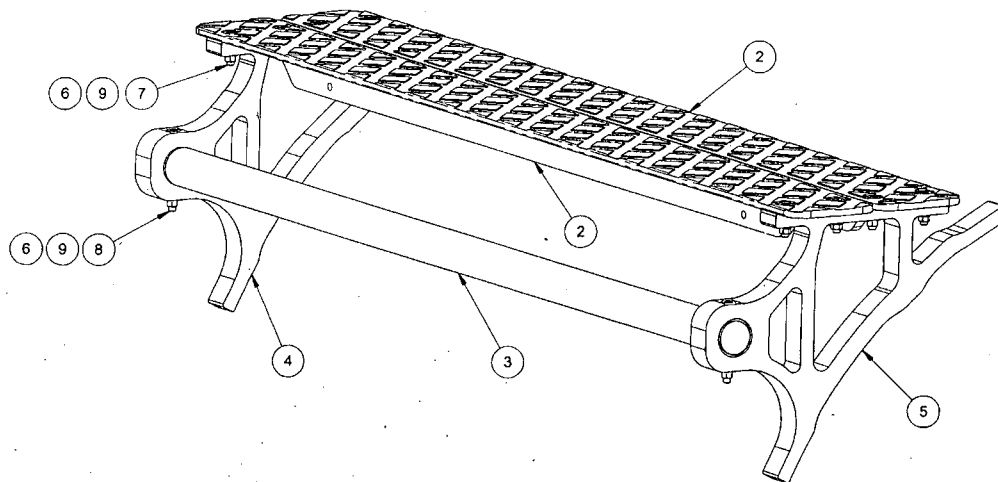
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**D4526-042 MAINTENANCE STEP ASSEMBLY**

ITEM	QTY -042	PART NUMBER	DESCRIPTION
1	X	D4526-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4526-043	TUBE ASSEMBLY
4	1	D4527-1	BRACKET
5	1	D4527-3	BRACKET
6	10	MS21042L3	NUT
7	8	MS24694-S55	SCREW
8	2	MS24694-S75	SCREW
9	10	NAS1149D0332J	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 82315 MLJ  
12/03/28

**RELEASED**  
2011-11-28  
M

A	NEW ISSUE	RF	11.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4526	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASSY	NTS
DATE	11.11.22	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

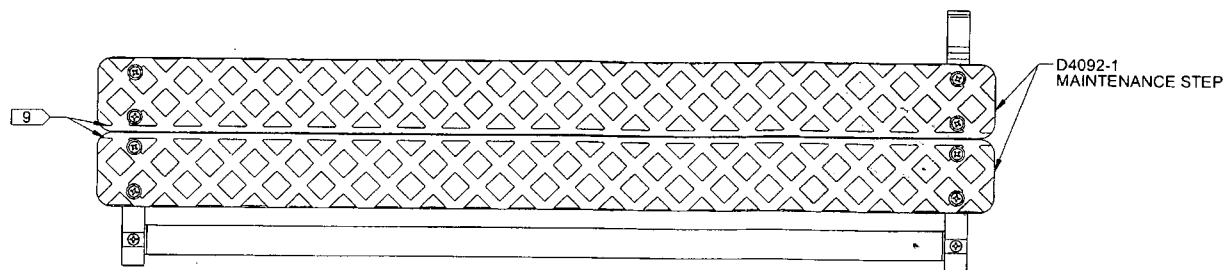
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

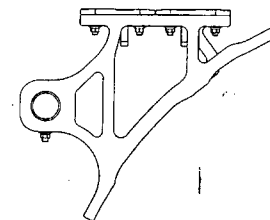
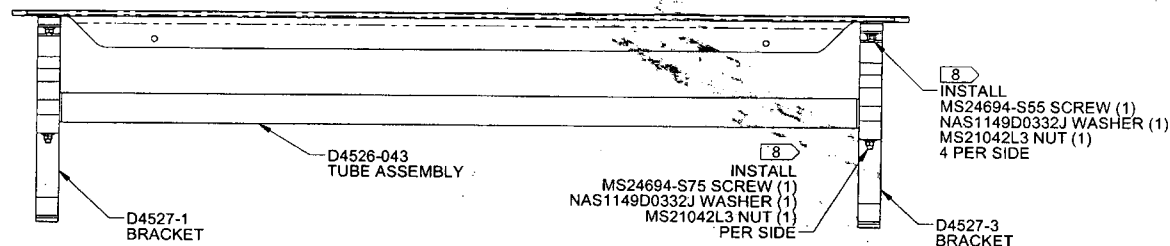
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**NOTE:** Date & initial all entries



82315



# **D4526-042 MAINTENANCE STEP ASSEMBLY**

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2011-11-28  
*AMP*

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 7.09 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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MFG. APPR.	<i>[Signature]</i>	<b>D4526</b>	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>MAINTENANCE STEP ASSY</b>	NTS
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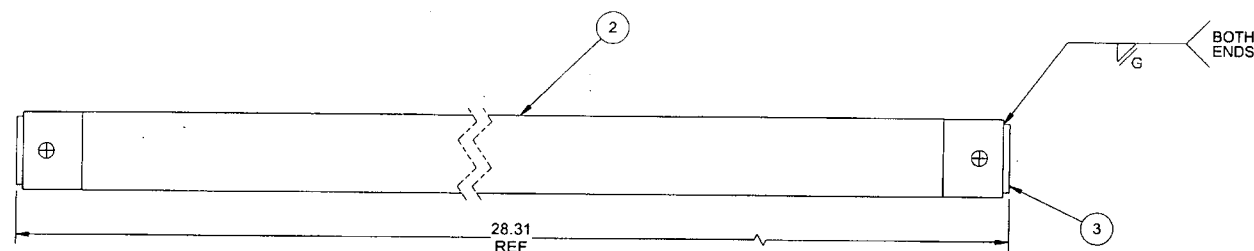
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**NOTE:** Date & initial all entries

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4526-043	TUBE ASSEMBLY
2	1	D4526-1	TUBING
3	2	D4526-3	CAP

82315



**D4526-043 TUBE ASSEMBLY**

RELEASED  
2011-11-28  
ND

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 1.32 lbs
- 8) WELD PER QSI 004

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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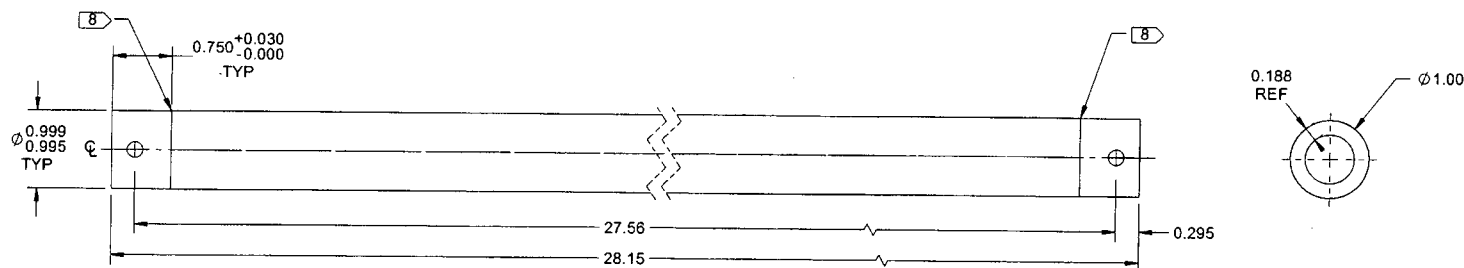
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**D4526-1 TUBING**

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**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082  
OR QQ-A-200/8 OR QQ-A-225/8  
REF DART SPEC M6061T6T1.000W.188
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs
- 8) MIN RADIUS OF TRANSITION OF R0.06

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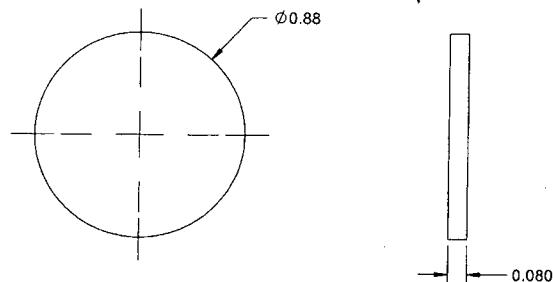
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**D4526-3 CAP**

**RELEASED**  
 2011-11-28  
 [Signature]

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM ROUND BAR  
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221  
 REF DART SPEC M6061T6R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.005 lbs

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